

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012360**Date Inspected:** 08-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Segment 9BW				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT)

This QA inspector performed Visual Testing (VT) on OBG Segment 9BW and VT indications are confirmed by Magnetic Particle Testing (MT) on area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The indications are clearly marked on the material near the weld for future repair. The members are identified as OBG Segment 9BW. The weld designations reviewed are as follows:

OBG Segment 9BW-PP75 West Side

1. FB023-006-092
2. FB003-139-004

OBG Segment 9BW-PP74 East Side

1. FB019-007-093
2. FB003-136-005
3. FB011-023-004

WELDING INSPECTION REPORT

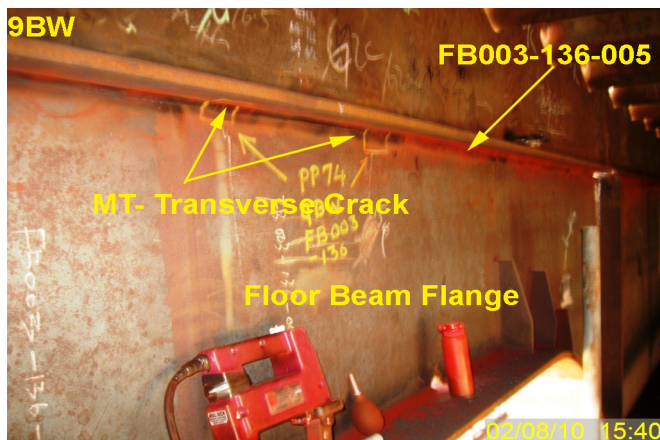
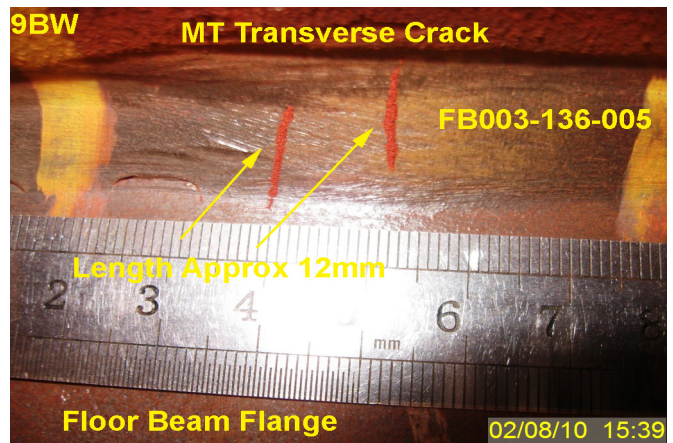
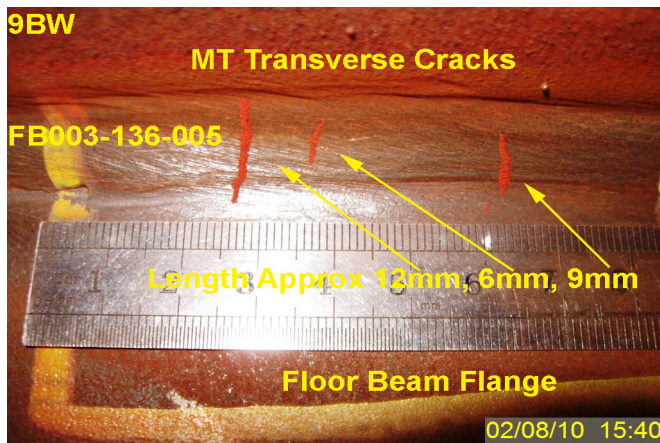
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Description of Incident: During random Quality Assurance Visual review of welds located on segment 9BW, this Quality Assurance Inspector (QA) discovered five (5) Transverse linear indications measuring approximately 6 to 12mm in lengths. The indications were discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA. ZPMC Quality Control MT Technicians claimed that magnetic particle testing have been performed on these welds that require 25% MT. The indication is clearly marked on the material near the weld. The welds are identified as FB003-136-005. The panel point is identified as a PP74. This weld is a Fillet weld joining the Floor beam Web to Flange. The Floor Beam Flange weld is identified as Non SPCM. For further information, please see the attached pictures

BLAST SHOP 1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 8CE interior Corner Assembly, Bottom Panel, Deck Panel, Floor Beam and Longitudinal Diaphragms surfaces from the panel point 67.5 to 69 after grit blasting and also carried out random visual inspection on segment 8CE exterior such as Bottom Panel, Deck Panel, and Side Panels. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
